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D412-630-032
Job Sheet 198364



Part No: D412-630-032

Job Qty: 2 pcs

Part Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/25/19

Job Tracking No:

Due Date: 8/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 18175

Note: DWG IIN D412-630 REV O SHEET 24, D3462 REV C IPP REV. A 05.11.21 NEW ISSUE EC IPP REV. B 05.12.19 updated pick list EC IPP REV.C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D 10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01 removed qty1 an310-4 EC verified by: DD IPP REV: F 16.06.23 AS PER IIN REV.O DD VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	8/8/19		0.00	0.62	Small Fab - 1		SMB 19/8/19
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	8/8/19		0.00	0.00	QC 5 - 10		DAS 19 9-06
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 1-1 - Pick Kit - B4B	2 pcs	8/8/19		0.00	0.00	Packaging 1 - 1 - B4B		
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		

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				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	NL
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36	
140 QC 4	2 pcs	8/8/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	DAS
				QC 4 - 68	75
				QC 4 - 72	9-89
				QC 4 - 74	8/12/2019
				QC 4 - 75	
150 Packaging 3-1 - Stock - B4B	2 pcs	8/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS
				Packaging 3 - 5 - B4B	75
				Packaging 3 - 6 - B4B	9-89
				Packaging 3 - 7 - B4B	8/12/2019
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

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					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
155	DC - 1 - B4B	2 pcs	8/8/19	0.00 0.00	DC - 1 - B4B	DAS 21 AUG 12 2019
					DC - 2 - B4B	9-89
160	QC 21 - FG	2 pcs	8/8/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	DAS 21 AUG 12 2019
					QC 21 - SA - 53	9-89

Part Op 110 - (Small Fab) Assemble as per IIN D412-630 ****ensure tension to retract step is 11 to 18 lbs before installing
 Descriptions: lockwire.**** A/R MS20995C41 batch:_____

120 - (QC5- Inspect part completeness to step on W/O) ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. ENSURE STEP IS A RH:_____

130 - (Pick Kit)

140 - (QC4- 100% Inspect kits for completeness) VERIFY ORIENTATION OF D3462/D3463:_____

150 - (Identify as per dwg & Stock Location:_____) Identify and pack for shipping as per PPP D412-630-032 ENSURE STEP IS A RH:_____ Location:FG034

155 - (Document Control) Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004

160 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310-4 ✓	Nut	2 Ea (1 ea)	110-Small Fab - 1	5151800
AN310-7 ✓	Nut	2 Ea (1 ea)	110-Small Fab - 1	5157474
AN4C14 ✓	Bolt	2 Ea (1 ea)	110-Small Fab - 1	5156687
AN4CH3 ✓	Bolt	4 Ea (2 ea)	110-Small Fab - 1	5154312 x2 5162122 x2
D3443-041 ✓	Strut Weldment Assembly	2 pcs (1 ea)	110-Small Fab - 1	5182502
D3443-043 ✓	Strut Weldment Assembly	2 pcs (1 ea)	110-Small Fab - 1	5162394
D3443-9 ✓	Pin	4 pcs (2 ea)	110-Small Fab - 1	5111660 x2 5159088 x1
D3454-7 ✓	Bushing	4 pcs (2 ea)	110-Small Fab - 1	5159293
D3455-1 ✓	Spacer	4 pcs (2 ea)	110-Small Fab - 1	5141963
D3463-042 ✓	Step Weldment Assembly	2 pcs (1 ea)	110-Small Fab - 1	F163828 x1 5202841
D3465-1 ✓	Washer	2 pcs (1 ea)	110-Small Fab - 1	F749356
MS24665-227 ✓	Cotter Pin	2 Ea (1 ea)	110-Small Fab - 1	F1135671
MS24665-302 ✓	Cotter Pin	2 Ea (1 ea)	110-Small Fab - 1	5156979
AN310-4	Nut	2 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5156896
AN310-5	Nut	4 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5101834
AN3C5A	Bolt	6 Ea (3 ea)	130-Packaging 1-1 - Pick Kit - B4B	5082907
AN44-C12	Eye Bolt	2 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5116968
AN4C15	BOLT	2 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5157315
AN5C11	Bolt	2 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5162159
AN5C15	Bolt	2 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	m135704 x1 m138336 x1
D3454-1	Bushing	2 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5077631
D3454-3	Bushing	4 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5142047
D3454-5	Bushing	4 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5142072
D3455-1	Spacer	8 pcs (4 ea)	130-Packaging 1-1 - Pick Kit - B4B	5141963
D3455-3	Spacer	4 pcs (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	5196731
D3462-042	Bracket Assembly	2 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5114104
D3672-5	Washer, Phenolic	2 pcs (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	F153354
MS21043-3	Nut	6 Ea (3 ea)	130-Packaging 1-1 - Pick Kit - B4B	5176493
MS24665-227	Cotter Pin	4 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	m135671
MS24665-229	Cotter Pin	4 Ea (2 ea)	130-Packaging 1-1 - Pick Kit - B4B	m135671
NAS1149C0363R	Washer (AN960C10)	14 Ea (7 ea)	130-Packaging 1-1 - Pick Kit - B4B	5181423
NAS1149C0563R	Washer (AN960C516)	2 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5161660
AN3C6A	Bolt	2 Ea (1 ea)	130-Packaging 1-1 - Pick Kit - B4B	5049457

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Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN310-4	2	84	0
	AN310-7	2	26	0
	AN4C14	2	27	0
	AN4CH3	4	22	0
	D3443-041	2	2	0
	D3443-043	2	2	0
	D3443-9	4	15	0
	D3454-7	4	14	0
	D3455-1	4	54	0
	D3463-042	2	2	0
	D3465-1	2	16	0
	MS24665-227	2	33	0
	MS24665-302	2	890	0
130-Packaging 1-1 - Pick Kit - B4B	AN310-4	2	84	0
	AN310-5	4	38	0
	AN3C5A	6	749	0
	AN3C6A	2	141	0
	AN44-C12	2	28	0
	AN4C15	2	46	0
	AN5C11	2	25	0
	AN5C15	2	33	0
	D3454-1	2	11	0
	D3454-3	4	26	0
	D3454-5	4	19	0
	D3455-1	8	54	0
	D3455-3	4	59	0
	D3462-042	2	5	0
	D3672-5	2	431	0
	MS21043-3	6	652	0
	MS24665-227	4	33	0
	MS24665-229	4	120	0
	NAS1149C0363R	14	657	0
	NAS1149C0563R	2	458	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S204202



Part: D412-630-032

Job No: 198364

Serial No/Batch: S204202

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-69 Issue 7 ~~FAA STC~~ SR00595NY 08/05/20, FAA ST

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
1	1	D3672-5	WASHER (OR NAS1515H5)
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
2	2	AN3C5A	BOLT
1	1	AN3C6A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	NAS1149C0363R	WASHER (OR AN960C10)
1	1	NAS1149C0563R	WASHER (OR AN960C516)
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP.
SEE FIGURE 13B (D412-630-023/-024 KITS) OR FIGURE 16B (D412-630-033/-034 KITS).

Change Record

PAGE 1 OF 1

Part Number: D412-630-031/-032Description: PILOT/CO-PILOT STEP, LH/RH (FOLDING)[illegible]